

Work Order ID 103263

Thursday, June 20, 2013 11:15:32 AM

103263

Page 1

Item ID: D4097-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: ARMREST ASSY
 Start Date: 6/20/2013 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 6/24/2013 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MP Date: 10-6-20 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4097	A

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: <u>ST273</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

3X 13/07/02

16 13/07/02

(+3)

3

13-07-03

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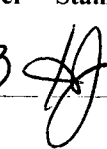
103263

Page 2

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Revision ID: Stop ***NS2***
Item Name: ARMREST ASSY
Start Date: 6/20/2013 Start Qty: 3.00 ***3*** Cust Item ID:
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

13/7/3 

U130703

Picklist Print

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Work Order ID: 103263
Parent Item: D4097-041
Parent Item Name: ARMREST ASSY

Start Date: 6/20/2013 Required Date: 6/24/2013
Start Qty: 3.00 Required Qty: 3.00

Comments: IPP Rev:A as per ECN10-573 DD 10.05.18 verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3696-041 Arm Assembly		Manufactured	No			100	Each	4.0000	1	3		6/13/07/02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST271		4							
				88400		2				2			
				90081		1							
				92408		1							
D4098-041 Armrest Cushion Assembly		Manufactured	No			100	Each	5.0000	1	3		6/13/07/02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST188		5							
				92377		5				3			
D4099-1 Bracket		Manufactured	No			100	Each	3.0000	1	3		6/13/07/02	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST247A		3							
				87903		3				3			

Picklist Print

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Work Order ID: 103263

Parent Item: D4097-041

Parent Item Name: ARMREST ASSY

Start Date: 6/20/2013

Required Date: 6/24/2013

Start Qty: 3.00

Required Qty: 3.00

MS21042L3

Purchased

No

100

Each

4,025.0000

3

9

Nut

Location

Loc Qty

Loc Code

FP001

3

122141

3

GA

18

122452

18

ST314

2229

111668

11

117885

32

119017

55

119075

138

123265

43

M126036

1950

ST506

1775

123900

954

124291

821

MS24693-C273

Purchased

No

100

Each

68.0000

5

15

SCREW

Location

Loc Qty

Loc Code

ST300

68

122539

6

124365

62

MS24693-C277

Purchased

No

100

Each

21.0000

3

9

Screw

Location

Loc Qty

Loc Code

ST300

21

113644

21

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 103263
Parent Item: D4097-041
Parent Item Name: ARMREST ASSY

Start Date: 6/20/2013 Required Date: 6/24/2013
Start Qty: 3.00 Required Qty: 3.00

NAS1149D0332J Purchased No Each 3,550.0000
Washer

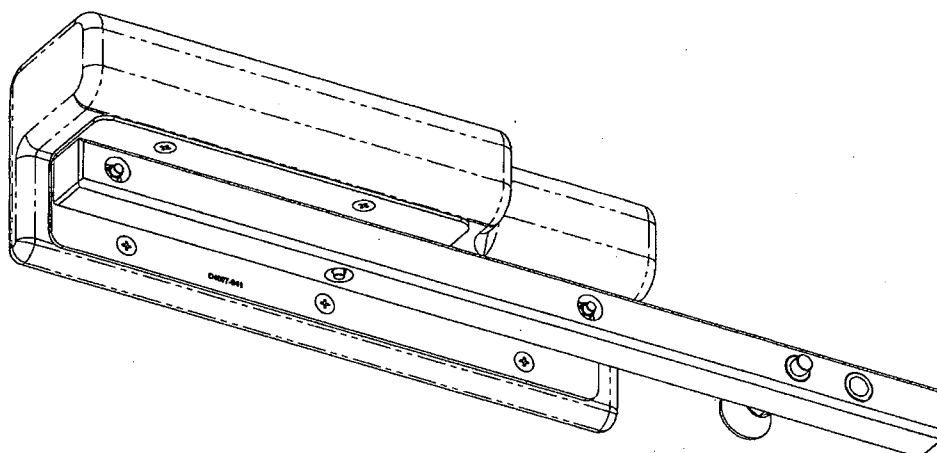
9 *ES* 13/07/02

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST293	165	
125268	165	
ST294	3385	
122973	68	
125044	338	
m125807	2979	

9

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4097-041	ARMREST ASSEMBLY
2	1	D3696-041	ARM ASSEMBLY
3	1	D4098-041	CUSHION ASSEMBLY
4	1	D4099-1	BRACKET
5	3	MS21042L3	NUT
6	5	MS24693-C273	SCREW
7	3	MS24693-C277	SCREW
8	3	NAS1149D0332J	WASHER (OR AN960JD10L)



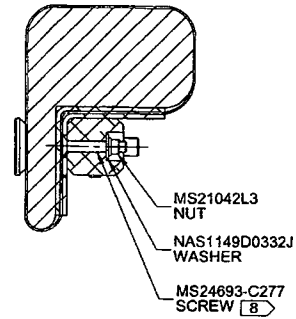
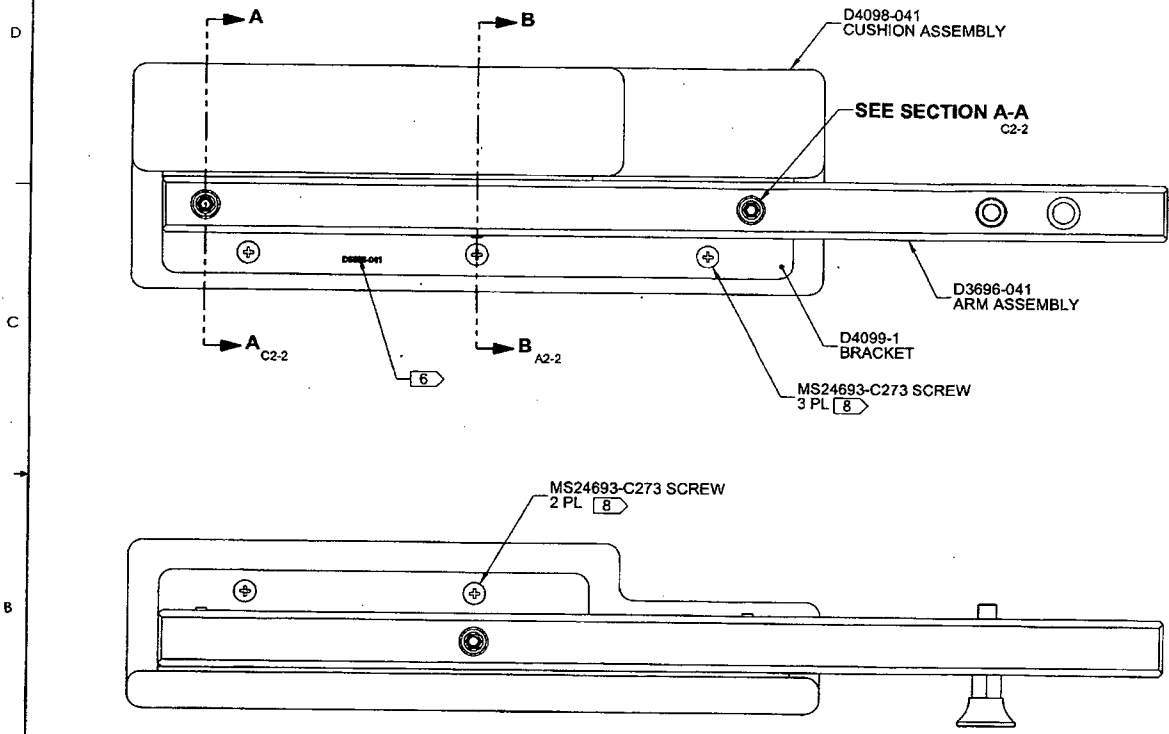
D4097-041 ARMREST ASSEMBLY

RELEASED
2010-05-17
and

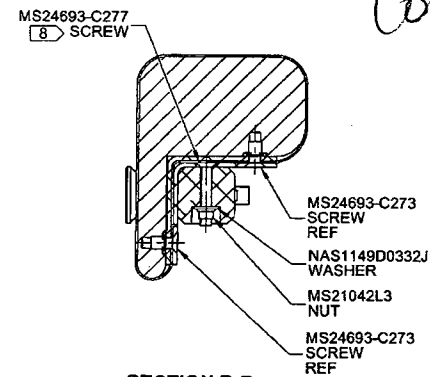
A	NEW ISSUE	MB	10.05.07
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		D4097	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
DATE	10.05.07	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



SECTION A-A
C7-2
D4-2



SECTION B-B
C6-2

603263

RELEASED
2010-05-17

- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4097-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
 - 7) WEIGHT: 2.66 lbs
 - 8) TORQUE SCREWS TO 20-25 in-lb.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4097	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARMREST ASSEMBLY	NTS
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8 7 6 5 4 3 2 1